

WHAT IS CLAIMED IS:

1. A grinding method simultaneously grinding plural grinding portions of a workpiece by plural grinding wheels moved individually each other, comprising:
terminating said grinding by a predetermined grinding wheel prior to a
5 termination of said grinding by the other grinding wheel.
2. A grinding method according to claim 1, wherein
said grinding includes plural grindings; and
each said grinding has a same content of said grinding by each grinding wheel.
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3. A grinding method according to claim 1 or claim 2, wherein
a grinding condition of said each grinding by said each grinding wheel is
changed according to a result of measuring said grinding portions.
4. A grinding method according to one of claim 1 to claim 3, wherein
15 said each grinding by each grinding wheel has plural processes of different
velocity of a grinding feed; and
a removable amount of said grinding portion by said predetermined grinding
wheel is set less than a removable amount of said grinding portion by the other
20 grinding wheel in a slower grinding feed velocity of said grinding processes.
5. A grinding method according to one of claim 1 to claim 4, wherein
said grinding by the other grinding wheel starts a predetermined time after a
start of said grinding by said predetermined grinding wheel.
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6. A grinding method according to one of claim 1 to claim 5, wherein
said predetermined grinding wheel remains in contact with said grinding
portion after said termination of its grinding; and
said predetermined grinding wheel is retracted at first in slow speed at the
30 same time with the other grinding wheel after said termination of said grinding by the
other grinding wheel and then in rapid speed.